

Work Order ID 138513

Thursday, October 29, 2015 1:55:04 PM

138513

Page 1

Item ID: 647.3915 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Deflector
 Start Date: 10/29/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 11/13/2015 Req'd Qty: 1.00 *1* Customer:
 Reference: rework per NCR15-4759

Approvals: Process Plan: MF Date: 15-10-29 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.3900	C2

200 .000
 200
 Small Fab
 Small Fab
 Memo
 PULL FROM STOCK 647.3915 X 1 B131450 (WAS A RETURN AND ORIGINAL BATCH 120739)
 1x 120739 was found
 REAM HOLES 0.191 AIR TO REDUCE THICKNESS OF PRIMER
 2 0 32.1.15/1463

210 QC5- Inspect part completeness to step on W/O .000
 210
 QC
 Quality Control
 Memo
 2
 DAS 38 9-89
 NOV 03 2015

220 Identify as per dwg & Stock Location: cdk SS .000
 220
 Packaging
 Packaging
 Memo
 2
 BAS 27
 NOV 09 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Thursday, October 29, 2015 1:55:04 PM

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC21 - Final Inspection - Work Order Release	0.00							
230									
QC	Memo	0.00							
Quality Control									

MLJ NOV 03 2015

MLJ NOV 03 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐					
Misidentified ☐	Past Due ☐						

Picklist Print

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Work Order ID: 138513

138513

Parent Item: 647.3915

647 3915

Parent Item Name: Deflector

Start Date: 10/29/2015

Required Date: 11/13/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV A RQ 14/05/28 VERIFIED BY DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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647.3915

Manufactured

No

Each

24.0000

1

647 3915

Deflector

Location

Loc Qty

Loc Code

CCK054

24

131243

18

131611

6

1 x 120739

1 x 131 450

MF

15-10-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Linda Lacelle

From: qpulse@dartaero.com
Sent: March-31-15 11:36 AM
To: Patrick Smith; Linda Lacelle
Subject: Action added to Non Conformance
Attachments: Locate Record.qpulse

Details: An action has been added to the following Non-Conformance:

Number	NCR15-4759
Report	Non-Conformance Report
Process	Employee Suggestion

Details	Extra steps required to complete assemblies and sub-assemblies. This is due to the thickness of the primer applied to parts which ranges from acceptable to way too thick. Examples: 647.3915 B120739 = too much primer inside 0.191" holes; 146.3314 B127669 = primer too thick and part can't fit inside 647.9711 B115251 or 647.9710 B121355. Similar issue witnessed on other CCK parts.
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Owner	Forbes, Nigel
Target Date	

Type	Corrective Action
Number	2
Owner	Lacelle, Linda
Details	Issue W/O's to have parts from stock reworked.

DQA: _____ Date: _____



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		OTHER : ☐							

List Lots

Page 1 of 1

Thursday, October 29, 2015 1:45:06 PM

Criteria : Item ID: 647.3915 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
647.3915 Deflector	Main Warehouse CCK054	131243	9/21/2015	18.0000	QC21		
	Main Warehouse CCK054	131450	9/21/2015	1.0000	<i>-originally</i> QC21		<i>120739.</i>
	Main Warehouse CCK054	131611	9/28/2015	6.0000	QC21		
Total:				25.0000			

L.138513

DQA: _____ Date: _____



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